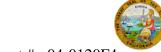
### **DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453

(707) 649-5493



No

N/A

Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 1.28

OBG/Tower

# WELDING INSPECTION REPORT

Resident Engineer: Casey, William **Report No:** WIR-027869 Address: 333 Burma Road **Date Inspected:** 29-Jun-2012

City: Oakland, CA 94607

**OSM Arrival Time:** 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1730 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: American Bridge/Fluor Enterprises, a JV **Location:** Job Site

**CWI Name:** See Below **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** 

**Component:** 

**Delayed / Cancelled:** Yes 34-0006

#### **Summary of Items Observed:**

**Bridge No:** 

At the start of the shift this Quality Assurance Lead Inspector (QAI) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) Quality Control (QC) personnel. The observations and inspections were performed as noted below:

A). This Quality Assurance Lead Inspector (QALI) assigned the QA Inspectors to the following, but not limited to the work station(s) listed, to observe the welding and the QC inspection of the following:

Joselito Lizardo-Tower/Shear Plates (Observation of excavations, repair welding, QC inspection and testing of ESW).

Rodney Patterson-Tower/Shear Plates (Ultrasonic testing of ESW).

William Clifford Tower/Shear Plates (Ultrasonic testing of ESW).

Matt Daggett-OBG W13 (Observations of welding and QC inspection of deck field splices).

Scott Croff-Tower/Shear Plates(Ultrasonic testing of ESW).

NOTE: See QA daily Weld Inspection Reports (WIR) and NDE reports for additional information and details.

Quality Assurance Lead Inspector (QALI) Summary

# WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Lead Inspector (QALI) observed the QA Inspector's Joselito Lizardo, Rodney Patterson, Scott Croff and Matt Daggett monitor the work performed by the QC inspectors at random intervals and also observed the QA Inspectors verify the welding parameters, the minimum preheat and the maximum interpass temperatures for compliance with the contract specifications. The QAI's utilized a Fluke 337 clamp meter to measure the electrical welding parameters, Tempil Heat Indicators and/or a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. At the conclusion of the shift, this QA Lead Inspector discussed and reviewed the work performed by the QAI's in regards to the various observations and the verifications of the WPS's, consumables, welding parameters, preheat and interpass temperatures. The QAI observations of the QC inspection and verification of the welding parameters performed on this date appeared to comply with the contract specifications and no issues were noted during this shift.

Tower/Shear Plates ESW, Ultrasonic Testing

In a conversation with Robert Mertz, QA Levell III, it was discussed that further review and research were required for the Ultrasonic Testing of the ESW in regards to determine relevant and non-relevant longitudinal indications. At the conclusion of this discussion this QA Lead Inspector and Mr. Mertz traveled to the tower to further discuss this with QA technicians, Rodney Patterson and William Clifford. At the conclusion of this discussion Mr. Mertz, Mr. Patterson and Mr. Clifford decided to utilize alternate techniques to determine the nature of the indications that were found during the UT testing. Later in the shift and at the conclusion of utilizing the alternate techniques, pitch catch, through transmission and conventional testing utilizing a 45 degree plastic wedge it was determined that the indications were the grain boundaries of the weld material and that a revision of the Supplemental Ultrasonic Test Procedure would be required.

This QA Lead Inspector also commence review of RWR's that have been received and also started to generate a spread sheet.

## **Summary of Conversations:**

There were general conversations with Quality Control Lead Inspector, Bonifacio Daquinag, Jr., at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

#### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Reyes, Danny	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer